

Work Order ID 85635

June-12-12 11:35:14 AM

Item ID: D350-636-011

Accept

85635

Revision ID:

Item Name: Skidtube LH

Start Date: 12/06/2012 Start Qty: 1.00 *1*

Required Date: 26/06/2012 Req'd Qty: 1.00 *1*

Reference:

Approvals: Process Plan: MLJ Date: 12/06/12 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------|--------------|----|------|------------------|-------|--|--|--|--|
| Draw Nbr | Revision Nbr | SP | 0.00 | DAS 16 089 | 114b2 | | | | |
| D2750 | F | | 0.00 | | | | | | |
| D3492 | C | | | | | | | | |

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

JL for MLJ 12-7-26

85635

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Item ID: D350-636-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2Start Date: 12/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

110

Skidtubes

Skidtubes

0.00

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent
2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
debur.
4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade
fitting
5- Drill only two fwd step holes using DT9616. Ensure proper positioning.6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up
holes for ground handling and detail C to 0.500" (8 holes per side)9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB

12/06/28

SA1

12-07-13

BB

12/06/28

SA1 12-07-16

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Item ID: D350-636-011

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NS1

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Item Name: Skidtube LH

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NS2Start Date: 12/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch: M12260*SE 12/06/28*

12-Grind welds flush as per Dwg D2750

→ CF 12-7-3

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

*16-6**DAS 16**12/07/16*

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*0.00 DAS 16**12/07/16*

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N900040100

Setup

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NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 12/06/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 26/06/2012 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

1

16

12-7-16

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Quality Control

Memo

0.00

(1)

SAD

12-07-16

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Required Date: 26/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | | 0.00 | | | | | | | |
| *160* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. | | | | | | | | |
| | 2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. | | | | | | | | |
| | 3- Open float hole to 0.500" (4 per side) | | | | | | | | |
| | 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) | | | | | | | | |
| | 5-Deburr and blow out all chips from inside of tube | | | | | | | | |
| | 6- Prepare tube for welding, remove alodine as required. | | | | | | | | |
| | 7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>M122130</u> exp. date: <u>13-3-14</u> | | | | | | | | |
| | 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) | | | | | | | | |
| | A/R Aluminum Rod batch: <u>M122130</u> | | | | | | | | |
| | 9- At section AJ-AJ drill out x-bolt spacer to 0.404" | | | | | | | | |
| | 10-Grind welds flush as per Dwg D2750 | | | | | | | | |

BB 12/07/17

CF 12-7-17

38E20718

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Item ID: D350-636-011

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Setup

Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 12/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

DAS
16
9-3

17(A)23

170

QC

Quality Control

Memo

0.00

180

QC5- Inspect part completeness to step on W/O

0.00

DAS
16
9-3

17(A)23

180

QC

Quality Control

Memo

0.00

Dart Aerospace Ltd

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Setup Start

NS1

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Item Name: Skidtube LH

Stop

NS2

Start Date: 12/06/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 26/06/2012 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**
190

190

HandFinish

Hand Finishing

**Operation
Description**
Pressure Wash per QSI005 4.3

**Set Up/
Run Hours**
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

1 ✓ BK/12/7/23

200

200

Powdercoat

Powder Coating

M121841

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

2:30 3200 F
START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

IX ✓ MZ 12/07/23

210

210

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Inspect for foreign object per QSI 024

1 LH ✓ QP 12/07/24

| W/O: | | WORK ORDER CHANGES | | | | | |
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N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 12/06/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 26/06/2012 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

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| | | | | | | Stop | *NR2* |
| | QC: | Date: | SPC (Y/N): | Date: | | | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|----------------------------------|-------------------------------------|----------------|---------------|----------------------|-----------------------|-----------------------|--------------------------|------------------------|
| 220 *220* HandFinish | HandFinishing Memo | 0.00 | | | | 1L4 | X | (2) | 12/07/24 |
| | Hand Finishing | 1- Install inserts as per Dwg D2750 | | | | | | | |

| | | | | | | | | | |
|-----------------------------------|------------------------------|------|--|--|--|--|--|--|--|
| 230 *230* HandFinish | HandFinishing Memo | 0.00 | | | | | | | |
|-----------------------------------|------------------------------|------|--|--|--|--|--|--|--|

| | | | | | | | | | |
|----------------|-------------------------------|--|--|--|--|--|--|--|--|
| Hand Finishing | 1-Inspect for Foreign Objects | | | | | | | | |
|----------------|-------------------------------|--|--|--|--|--|--|--|--|

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 127130

EXP DATE: 14/07

4-assemble o-ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: 110348

5-Coat all exposed fasteners with "LPS Procyon" batch: 114596

| | | | |
|-----|---|-----|----------|
| 1L4 | X | (2) | 12/07/25 |
|-----|---|-----|----------|

| W/O: | | WORK ORDER CHANGES | | | | | | | |
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NS1

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Stop

NS2

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Required Date: 26/06/2012 Req'd Qty: 1.00 *1*

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

240 QC5- Inspect part completeness to step on W/O

0.00

DAS
16
9-89

240

QC

Quality Control

Memo

0.00

Notable

250

Pick Kit

0.00

250

Packaging

Packaging

Memo

0.00

IK

SP
12-7-26

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Quality Control

Memo

0.00

DAS
16
9-89

17/07/27

OK

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Date:

Run Start

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Date:

Stop

NR2

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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 270 | | 0.00 | | | | | | | |
| *270* | Packaging | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Package as per PPP D350-636-011 | | | | | | | | |
| | <i>Rev. I</i> | | | | | | | | |
| 280 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *280* | Memo | 0.00 | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | | | | | | | | | |

12/11/2012 C

12/18/11 H

QA/QC 12/20/11

12/27/11

| W/O: | | WORK ORDER CHANGES | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:19 AM

Work Order ID: 85635

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

85635
D350-636-011

Page 1

14

Start Date: 12/06/2012

Start Qty: 1.00

Required Date: 26/06/2012

Required Qty: 1.00

Comments:

- IPP Rev:I 02.09.25 Rearranged procedure steps KJ
- IPP Rev:J 06-03-23 As per Rev D JLM
- IPP Rev:K 06-07.13 As per dsi9343 EC
- IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
- IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
- IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
- IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
- DD verf:EC IPP Rev:P 10.06.22 revise
- seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
- DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | |
|---------|--|--------------|----|--|-----|------|----------|---|---|---|---|----------|
| D3492-1 | | Manufactured | No | | 230 | Each | 253.0000 | 8 | 8 | 8 | 8 | 12/07/24 |
|---------|--|--------------|----|--|-----|------|----------|---|---|---|---|----------|

| | | | |
|--------------------------|--|-----------|-----------|
| *D3492-1* Plug | | ** | SP |
|--------------------------|--|-----------|-----------|

Location Loc Qty Loc Code

| | | |
|---------|-----|--|
| FP002 | 238 | |
| 69531 | 8 | |
| 74444 | 2 | |
| 76235 | 4 | |
| 83259 ✓ | 224 | |
| FP-A | 15 | |
| 83098 | 15 | |

| | | | | | | | | |
|---------|--------------|----|-----|------|----------|---|---|----------|
| D3492-3 | Manufactured | No | 230 | Each | 163.0000 | 8 | 8 | 12/07/24 |
|---------|--------------|----|-----|------|----------|---|---|----------|

| | | | |
|--------------------------|--|-----------|-----------|
| *D3492-3* Plug | | ** | SP |
|--------------------------|--|-----------|-----------|

Location Loc Qty Loc Code

| | | | |
|-------|---------|-----|--|
| FP-A | 85461 ✓ | 163 | |
| 81967 | 5 | | |
| 83099 | 36 | | |
| 83529 | 122 | | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:19 AM

Page 2

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230

Each

168.0000

8

8

**

8

(DP)

12/07/24

NAS1611-010

O-RING

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

FP001 122151✓

168

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121415

4

121584

39

121723

50

NAS1149D0863J

Purchased No

250

Each

249.0000

2

2

**

SP

NAS1149D0863.J

WASHER

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

ST298

249

118078

34

119307

15

120308

100

121556

100

D2744

Manufactured No

110

Each

32.0000

1

1

**

8/6 12/06/28

D2744

Cap

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

LG002

32

62715

1

83412

31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:19 AM

Page 3

Work Order ID: 85635

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

85635
D350-636-011

Start Date: 12/06/2012

Start Qty: 1.00

Required Date: 26/06/2012

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

25.0000

1

1

**

D2600-3-RFNT

Extrusion Bent

| <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|-------|----------------|-----------------|
| LG | 86330 | 25 | |
| | 66875 | 7 | |
| | 73253 | 1 | |
| | 75021 | 1 | |
| | 75022 | 1 | |
| | 75023 | 1 | |
| | 81330 | 4 | |
| | 83305 | 1 | |
| | 83442 | 9 | |

1 33 / 140/28

D2743

Manufactured No

160

Each

272.0000

8

8

**

D2743

Crossbolt Spacer

| <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|-------|----------------|-----------------|
| LG | | 198 | |
| | 81965 | 55 | |
| | 83262 | 143 | |
| LG001 | | 74 | |
| | 67766 | 4 | |
| | 68251 | 3 | |
| | 73403 | 64 | |
| | 74445 | 1 | |
| | 79517 | 2 | |

BE 12/07/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:19 AM

Page 4

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

12.0000

1

1

**

D2739

350 I Beam

CF 12-7-17

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| LG | 12 | |
| 72155 | 1 | |
| 81508 | 1 | |
| 83447 | 3 | |
| 83448 | 5 | |
| 83548 | 2 | (1) |

D3490-3

Manufactured No

160

Each

42.0000

4

4

**

D3490-3

Cross Bolt Spacer

BED-07/8
B85420 *4

D3490-1

Manufactured No

160

Each

33.0000

4

4

**

D3490-1

Cross Bolt Spacer

SE12-07/8
B85419 *4

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| LG | 2 | |
| 81976 | 2 | |
| LG001 | 31 | |
| 62450 | 2 | |
| 74875 | 4 | |
| 77042 | 3 | |
| 83269 | 22 | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:19 AM

Page 5

Work Order ID: 85635**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH

85635
D350-636-011

Start Date: 12/06/2012**Start Qty:** 1.00**Required Date:** 26/06/2012**Required Qty:** 1.00

ALS4-1032-225

Purchased No

220

Each

683.0000

38

38

**

38

(SP)

12/07/24

AI S4-1032-225

Insert

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-----------------|-----|--|
| ST281 (22240 ✓) | 660 | |
| 108696 | 146 | |
| 110768 | 62 | |
| 118386 | 55 | |
| 118966 | 68 | |
| 121269 | 329 | |
| ST282 | 23 | |
| 120410 | 10 | |
| 120451 | 13 | |

D3793-3

Manufactured No

230

Each 28.0000

1

1

**

1

(SP)

12/07/24

D3793-3

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|---------|----|--|
| FP001 | 28 | |
| 83394 | 16 | |
| 83901 ✓ | 12 | |

AN8C35A

Purchased No

230

Each 66.0000

1

1

**

1

(SP)

12/07/24

AN8C35A

BOLT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|----------|----|--|
| FP002 | 65 | |
| 115960 | 1 | |
| 118286 | 14 | |
| 121275 ✓ | 50 | |
| ST346 | 1 | |
| 114442 | 0 | |
| 115188 | 0 | |
| 115960 | 1 | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured

No

230

Each

28.0000

1

1

**

1

(P)

12/07/24

D3793-1

Wearshoe

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 28 | |
| 82171 | 2 | |
| 83393 ✓ | 13 | |
| 83903 | 13 | |

D3488-041

Manufactured

No

230

Each

9.0000

1

1

**

1

(P)

12/07/24

D3488-041

Blade Fitting Assembly, LH



| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 83733 ✓ | |
| 61689 | 1 | |
| 82271 | 8 | |

D3794-3

Manufactured

No

230

Each

23.0000

1

1

**

1

(P)

12/07/24

D3794-3

Gasket

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP | 21 | |
| 83396 ✓ | 21 | |
| FP002 | 2 | |
| 74530 | 2 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:20 AM

Page 7

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

AN6C44A

Purchased

No

230

Each

78.0000

4

4

**

4

(DP)

12/07/24

AN6C44A

BOLT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG 122204 | 2 | |
| 103964 | 2 | |
| ST343 | 76 | |
| 121013 | 11 | |
| 121167 | 8 | |
| 121440 | 50 | |
| 121689 | 7 | |

MS21083C8

Purchased

No

230

Each

77.0000

1

1

**

1

(DP)

12/07/24

MS21083C8

NUT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| 304 121185 | 72 | |
| 121185 | 27 | |
| 121349 | 45 | |
| FP002 | 1 | |
| 115884 | 1 | |
| ST303 | 4 | |
| 115884 | 0 | |
| 118077 | 1 | |
| 119309 | 2 | |
| 119638 | 1 | |

D3536-25

Manufactured

No

230

Each

28.0000

1

1

**

(DP)

12/07/24

D3536-25

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP 83391 | 28 | |
| 833900 | 12 | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:20 AM

Page 8

Work Order ID: 85635

85635
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

331.0000

8

8

**

8

(2)

12/07/24

D3631-1

Washer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 316 | |
| 81874 | 2 | |
| 83588 | 314 | |
| ST072 | 15 | |
| 68062 | 2 | |
| 75548 | 13 | |

D3791-1

Manufactured No

230

Each

29.0000

1

1

**

1

(2)

12/07/24

D3791-1

Wearplate

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 29 | |
| 62239 | 2 | |
| 83392 | 15 | |
| 83902 | 12 | |

AN960C10L

NAS1149C0332 Purchased

No

230

Each

21.0000

38

38

**

38

(2)

12/07/24

*AN960C10L *

washer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST | 1220b3 | |
| 107534 | 21 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:20 AM

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Work Order ID: 85635

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

85635
D350-636-011

Start Date: 12/06/2012

Start Qty: 1.00

Required Date: 26/06/2012

Required Qty: 1.00

D2745

Manufactured

No

230

Each

106.0000

8

8

**

8

(DP)

12/02/24

D2745

Bushing

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|----|--------|---|
| FP | 65416✓ | 6 |
| | 79518 | 6 |

| | | |
|-------|-----|--|
| FP001 | 100 | |
|-------|-----|--|

| | | |
|-------|----|--|
| 69529 | 1 | |
| 76142 | 1 | |
| 83260 | 98 | |

AN3C5A

Purchased

No

230

Each

1,270.000

34

34

**

34

(DP)

12/07/24

AN3C5A

Bolt

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|--------|---|--|
| FP001 | 7 | |
| 115835 | 7 | |

| | | |
|-------|------|--|
| ST350 | 1263 | |
|-------|------|--|

| | | |
|---------|-----|--|
| 116419 | 28 | |
| 117343 | 13 | |
| 117764 | 7 | |
| 117872 | 2 | |
| 119749 | 23 | |
| 120423 | 28 | |
| 121068 | 12 | |
| 121255✓ | 500 | |
| 121444 | 150 | |
| 121708 | 500 | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:20 AM

Page 10

Work Order ID: 85635**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH***85635******D350-636-011*****Start Date:** 12/06/2012**Start Qty:** 1.00**Required Date:** 26/06/2012**Required Qty:** 1.00

D3537-1

Manufactured

No

230

Each

19.0000

3

3

**

3

(DP)

12/07/24

D3537-1

Wearpad

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 85457✓ | 19 |
| 81362 | 6 | |
| 83254 | 1 | |
| 83255 | 3 | |
| 84091 | 9 | |

NAS1149C0832R

Purchased

No

230

Each

256.0000

1

1

**

1

(DP)

12/07/24

NAS1149C0832R

WASHER

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST297 | 256 | |
| 114915✓ | 256 | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:20 AM

Page 11

Work Order ID: 85635***85635*****Parent Item:** D350-636-011***D350-636-011*****Parent Item Name:** Skidtube LH**Start Date:** 12/06/2012**Required Date:** 26/06/2012**Start Qty:** 1.00**Required Qty:** 1.00

AN3C6A

Purchased

No

230

Each

413.0000

4

4

**

4

DP

12/07/24

AN3C6A

BOLT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|----------|-----|--|
| FP001 | 1 | |
| 111982 | 1 | |
| ST351 | 412 | |
| 111982 | 2 | |
| 116419 | 23 | |
| 116549 | 2 | |
| 116704 | 12 | |
| 117619 | 10 | |
| 117688 | 1 | |
| 117872 | 5 | |
| 118422 | 13 | |
| 119449 | 21 | |
| 120423 | 3 | |
| 120693 | 150 | |
| 121682 ✓ | 170 | |

NAS1611-013

Purchased

No

230

Each

341.0000

8

8

DP

12/07/24

NAS1611-013

O-RING

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|----------|-----|--|
| FP001 | 341 | |
| 116582 | 5 | |
| 117291 | 2 | |
| 117887 | 53 | |
| 119623 | 36 | |
| 121584 | 15 | |
| 121825 ✓ | 188 | |
| 121826 | 42 | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:20 AM

Page 12

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

34.0000

1

1

**

1

(DP)

12/07/24

D3535-25

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 34 | |
| 62233 | 1 | |
| 81357 | 1 | |
| 82156 | 2 | |
| 83387 | 17 | |
| 83899 ✓ | 13 | |

D3794-1

Manufactured No

230

Each

26.0000

1

1

**

1

(DP)

12/07/24

D3794-1

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP | 6 | |
| 82167 | 6 | |
| FP002 | 20 | |
| 83395 ✓ | 20 | |

MS21043-6

Purchased No

230

Each

610.0000

4

4

**

4

(DP)

12/07/24

MS21043-6

NUT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 20 | |
| 103693 | 20 | |
| ST301 | 590 | |
| 117887 | 2 | |
| 118384 ✓ | 88 | |
| 120308 | 500 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:21 AM

Page 13

Work Order ID: 85635

85635
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Start Qty: 1.00

Required Date: 26/06/2012

Required Qty: 1.00

D3493-1

Manufactured No

250 Each 125.0000

2

**

D3493-1

Washer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST050 | 125 | |
| 77573 | 1 | |
| 82023 | 24 | |
| 83097 | 100 | |

MS21083C8

Purchased No

250 Each 77.0000

2

**

MS21083C8

NUT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| 304 | 72 | |
| 121185 | 27 | |
| 121349 | 45 | |
| FP002 | 1 | |
| 115884 | 1 | |
| ST303 | 4 | |
| 115884 | 0 | |
| 118077 | 1 | |
| 119309 | 2 | |
| 119638 | 1 | |

AN8C21A

Purchased No

250 Each 55.0000

2

**

AN8C21A

BOLT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST343 | 55 | |
| 118758 | 3 | |
| 121167 | 2 | |
| 121275 | 50 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

June-12-12 11:35:21 AM

Page 14

Work Order ID: 85635

85635

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 12/06/2012

Start Qty: 1.00

Required Date: 26/06/2012

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

138.0000

4

4

**

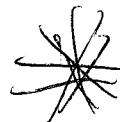
4

(DP)

12/07/24

*NAS1515H3L *

WASHER



| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FG | 40 | |
| 102472 | 40 | |
| ST277 | 98 | |
| 118686 | 3 | |
| 119438✓ | 1 | |
| 120360 | 11 | |
| 121243 | 2 | |
| 121556 | 81 | |

D2741

Manufactured

No

250

Each

54.0000

1

1

**

(SP)

K

D2741

Blade, 350 Skidtube

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST | -10 | |
| ST466 | 64 | |
| 71856 | 1 | |
| 79516 | 14 | |
| 83135 | 39 | |

D3532-1

Manufactured

No

250

Each

30.0000

2

**

(K)

2

SP 12-7-26

D3532-1

Spacer

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST053 | 30 | |
| 82041 | 5 | |
| 83319 | 25 | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|--|
| X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| X | | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| X | | | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| 1 | | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALL ALS-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (ϕ 0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL ▲
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL ▲

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. EST-035 MC

106112

RELEASED
09-22-14

| | | | |
|------------|--|---|---------------|
| F | INCORPORATE D819413 D7V (3) D3537-1 WRS QTY (5) (ZN C8-1) D3791-1/3 REPLACES D3535-13A-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN BB-1); D3481-34/4-1 HARDWARE UPDATED (ZN C18-8, 9, 10, 11); ADD NONG (12 AN8-13) (AN AG-1); REASON: REF. NCR 08-043 | PH | 08.07.16 |
| E | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (3) AN56151SH3L; REMOVE QTY (10) AN56151SH3L; REMOVE QTY (1) AN560C816; REMOVE QTY (2) MS21083CB | CB | 07.05.17 |
| D | ADD HOLES AND S/F ACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157 | PH | 06.01.05 |
| C | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740 | CP | 98.11.18 |
| B | CHANGE MS24694-S293 TO AN8-16A | CP | 98.09.01 |
| A | NEW ISSUE | DS | 98.04.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>PA</i> | DART AEROSPACE USA, INC. | |
| DRAWN | <i>PA</i> | PORT HADLOCK, WA | |
| CHECKED | <i>PA</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>AP</i> | D2750 | SHEET 1 OF 11 |
| APPROVED | <i>AP</i> | TITLE | SCALE |
| DE APPR. | <i>AP</i> | 350 SKIDTUBE ASSEMBLY | |
| DATE | 08.07.16 | COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS THE PROPERTY OF THE COMPANY. IT IS PROHIBITED FROM BEING COPIED OR DISCLOSED TO OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

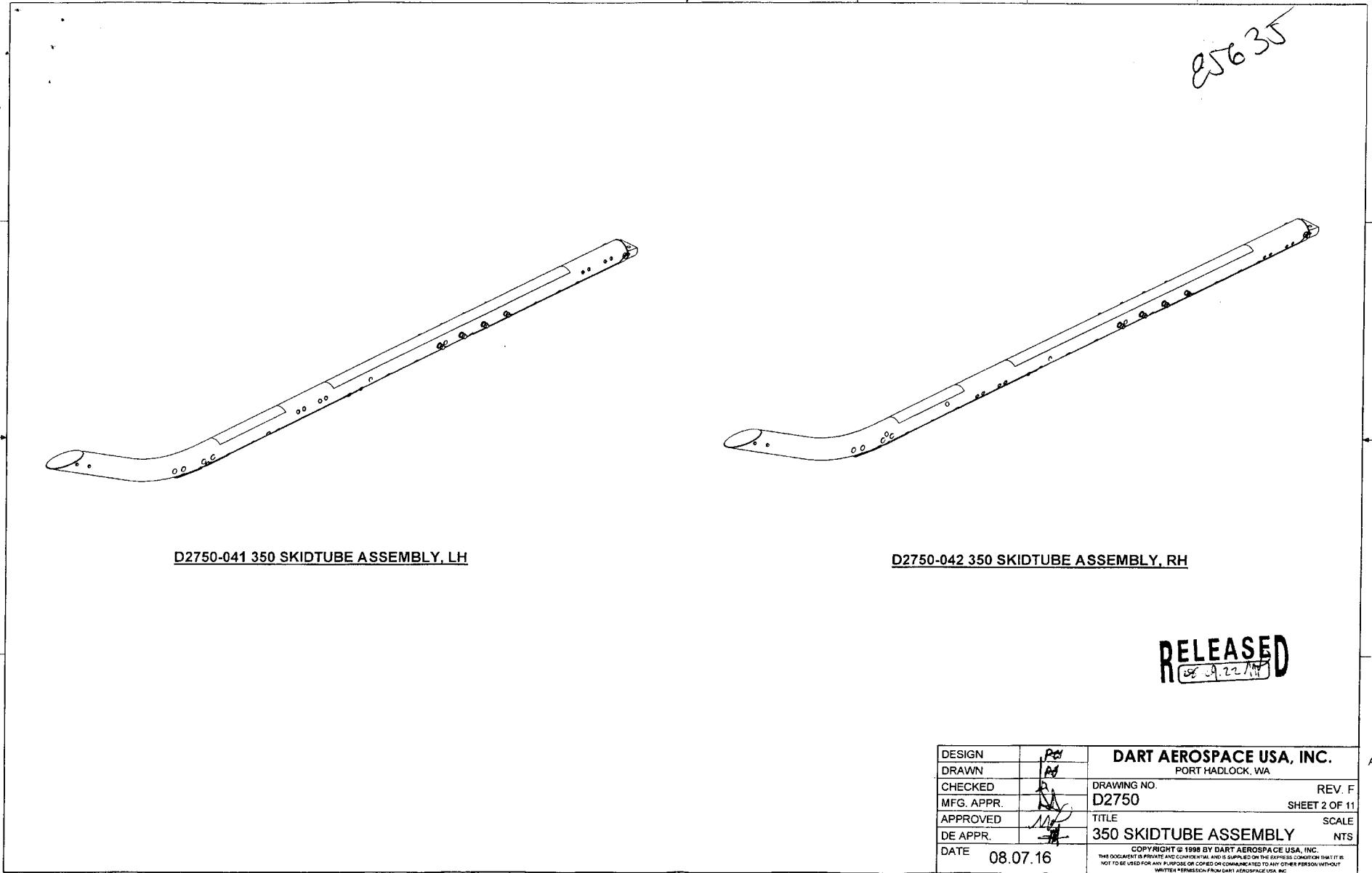
| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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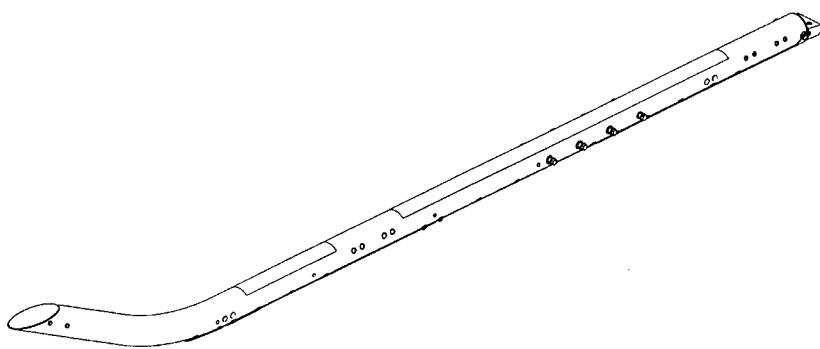
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

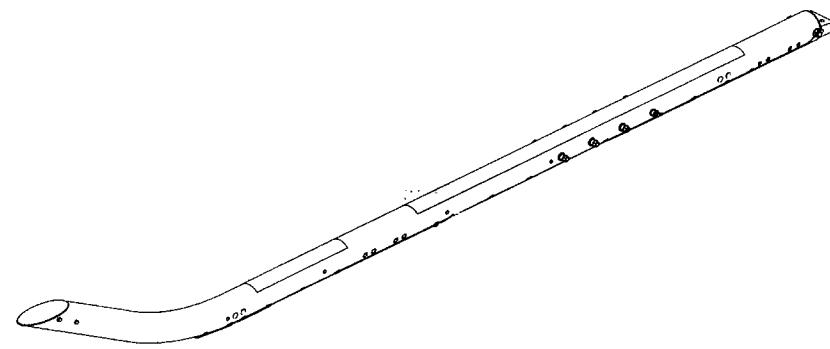
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

85635



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
68-9-227

| | | |
|------------|----------|---|
| DESIGN | Pd | DART AEROSPACE USA, INC. |
| DRAWN | Pd | PORT HADLOCK, WA |
| CHECKED | JA | DRAWING NO. REV. F |
| MFG. APPR. | NA | D2750 SHEET 3 OF 11 |
| APPROVED | MM | TITLE SCALE |
| DE APPR. | MM | 350 SKIDTUBE ASSEMBLY NTS |
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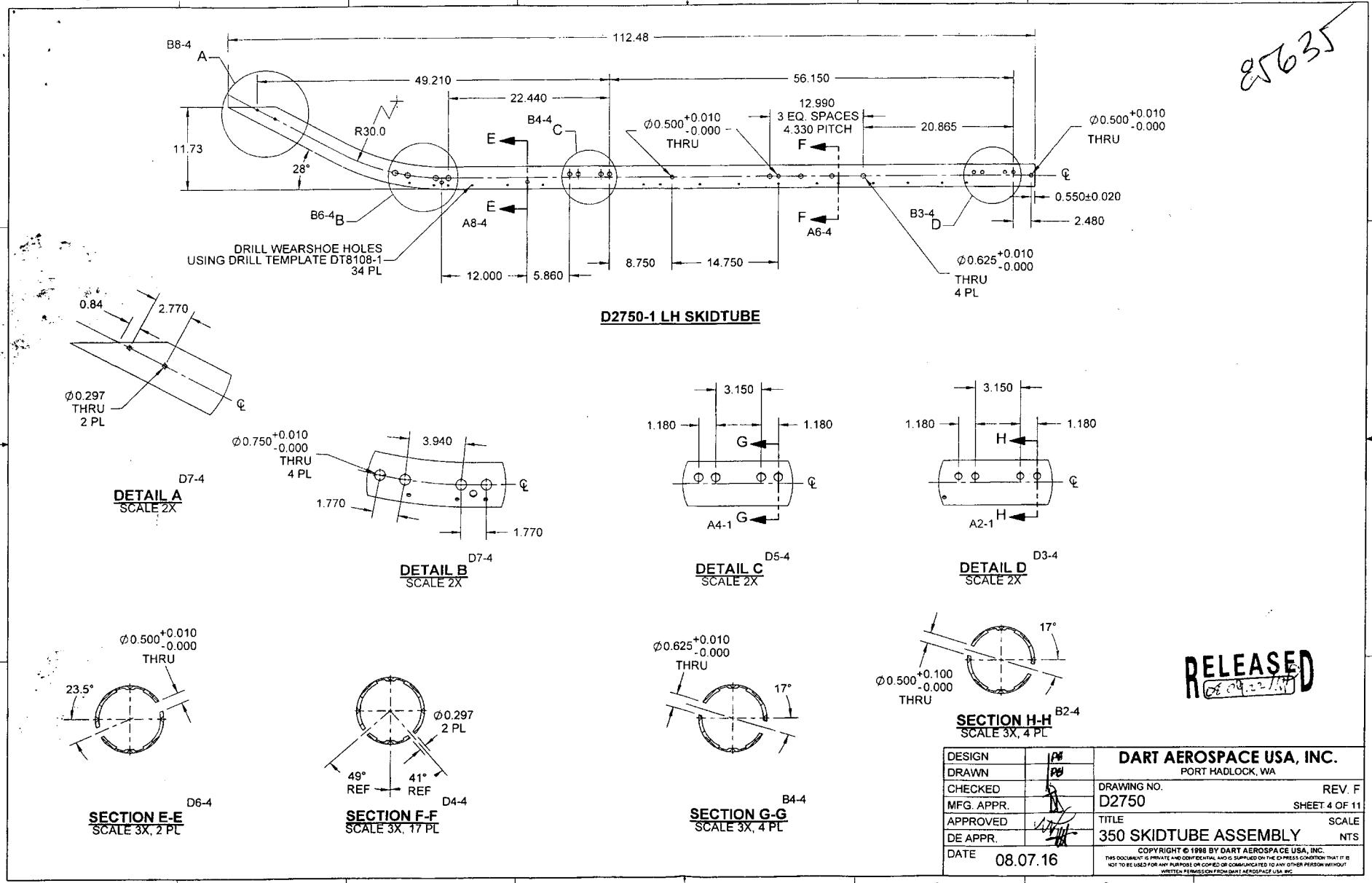
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | |
|------------|----------|-----------------------------|
| DESIGN | IPB | DART AEROSPACE USA, INC. |
| DRAWN | PB | PORT HADLOCK, WA |
| CHECKED | | DRAWING NO. D2750 |
| MFG. APPR. | | REV. F |
| APPROVED | | SHEET 4 OF 11 |
| DE APPR. | | TITLE 350 SKIDTUBE ASSEMBLY |
| DATE | 08.07.16 | SCALE NTS |

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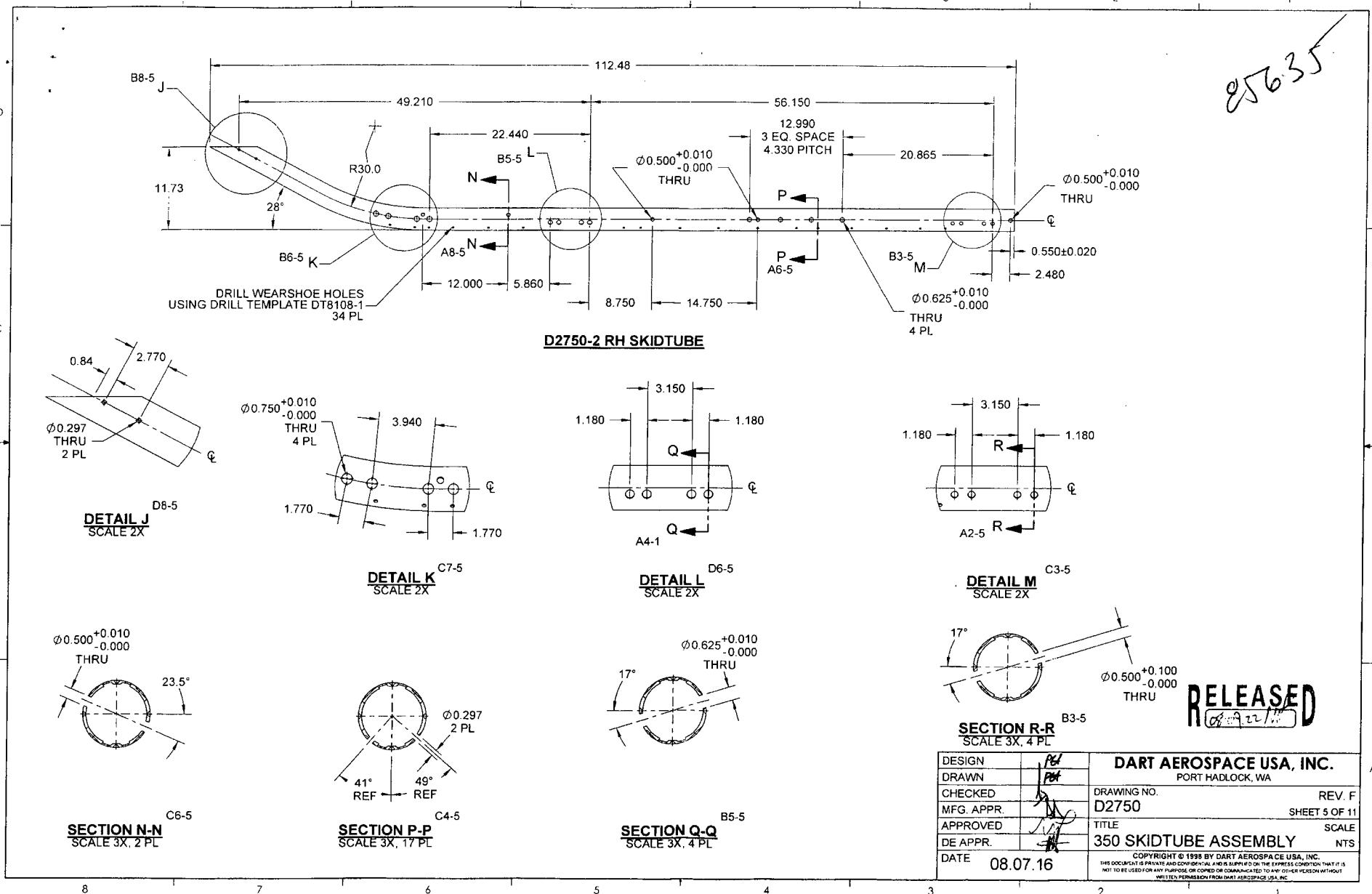
| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| DESIGN | 181 | DART AEROSPACE USA, INC. |
| DRAWN | PAE | PORT HADLOCK, WA |
| CHECKED | AB | DRAWING NO. |
| MFG. APPR. | AB | REV. F |
| APPROVED | AB | D2750 |
| DE APPR. | AB | SHEET 5 OF 11 |
| DATE | 08.07.16 | TITLE 350 SKIDTUBE ASSEMBLY NTS |

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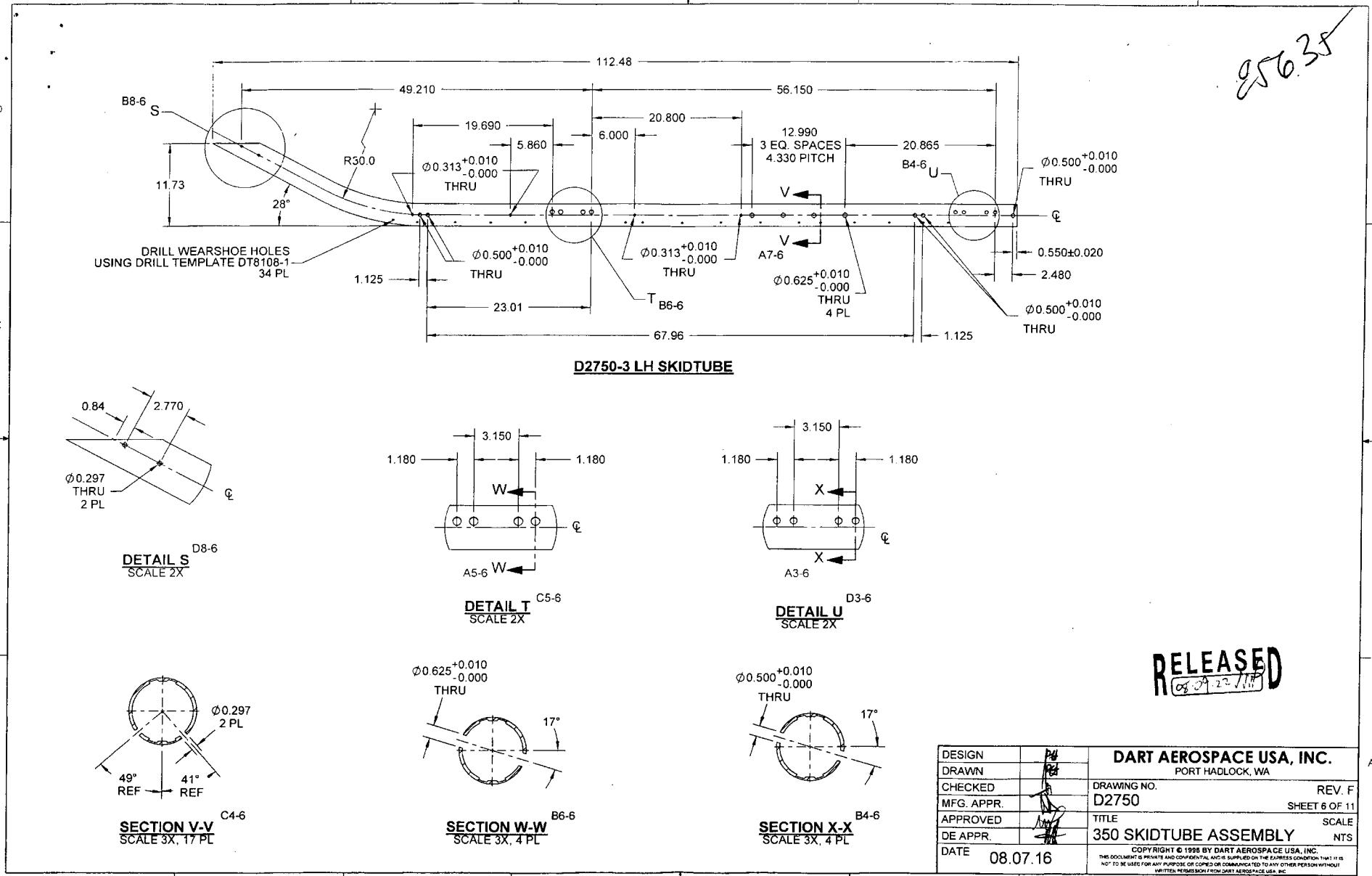
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



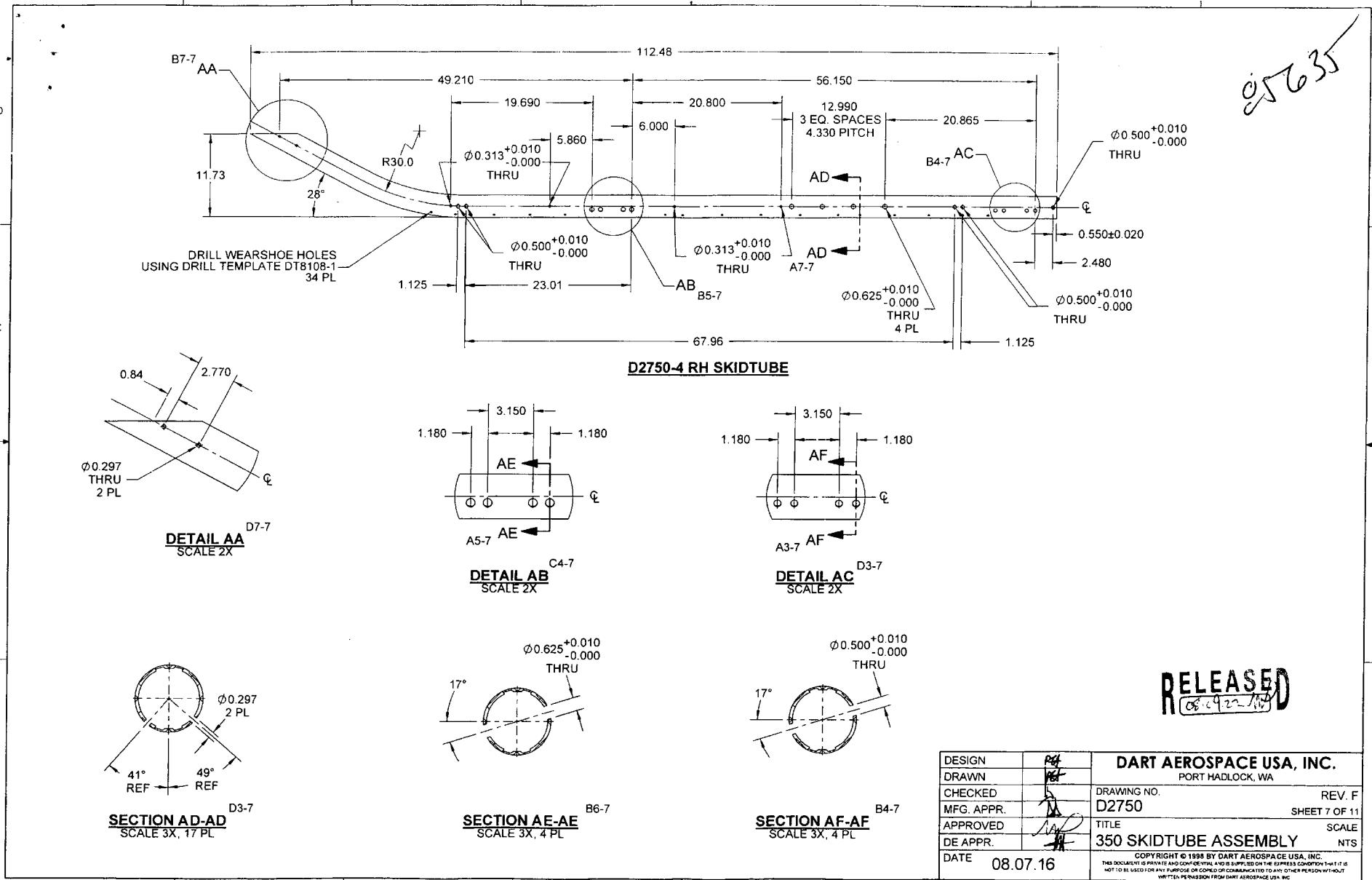
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| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



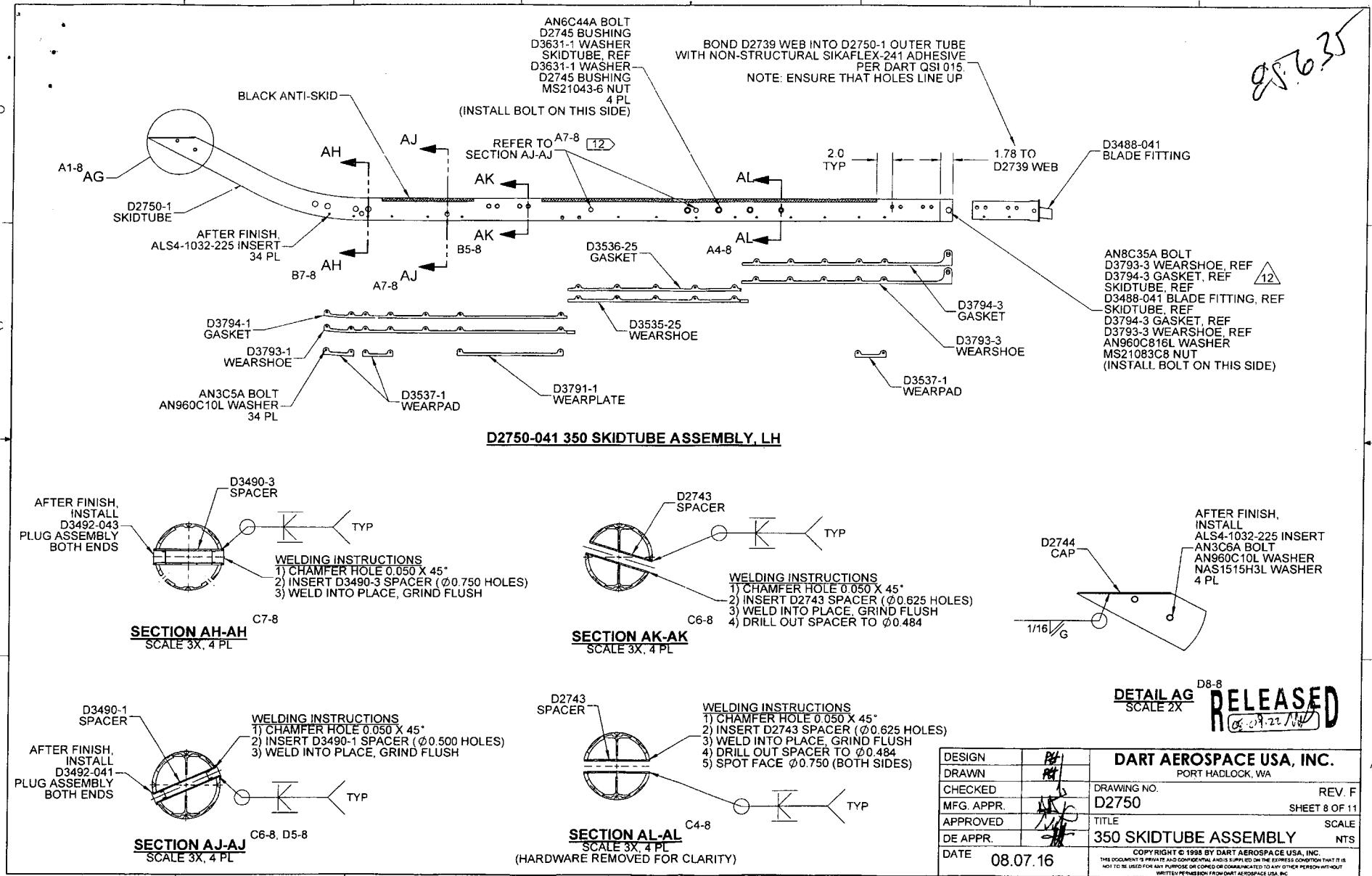
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



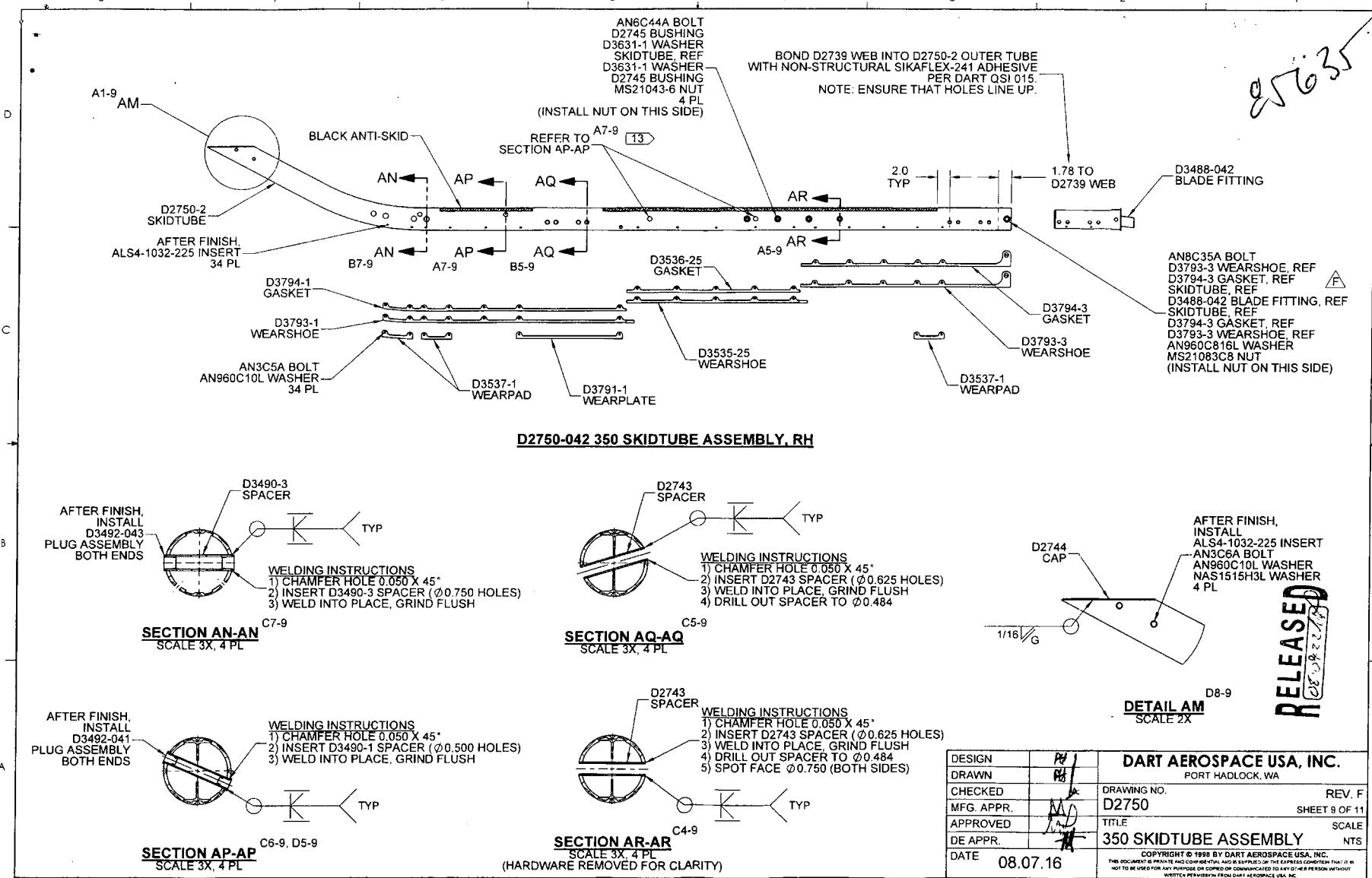
| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| DESIGN | P4 | DART AEROSPACE USA, INC. |
| DRAWN | P4 | PORT HADLOCK, WA |
| CHECKED | | REV. F |
| MFG. APPR. | M | DRAWING NO. |
| APPROVED | A | D2750 |
| DE APPR. | H | TITLE |
| DATE | 08.07.16 | SCALE |
| | | NTS |

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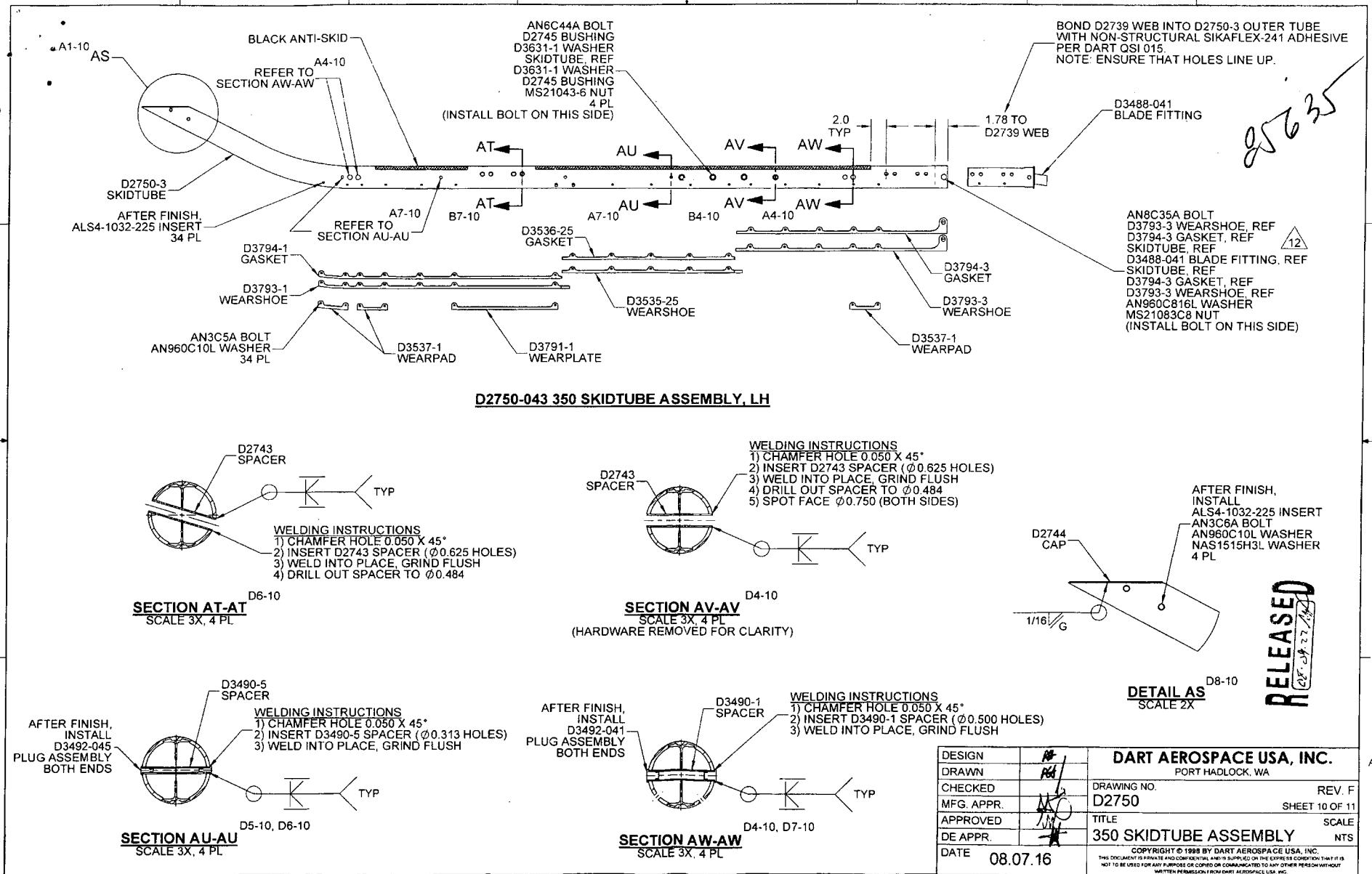
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|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



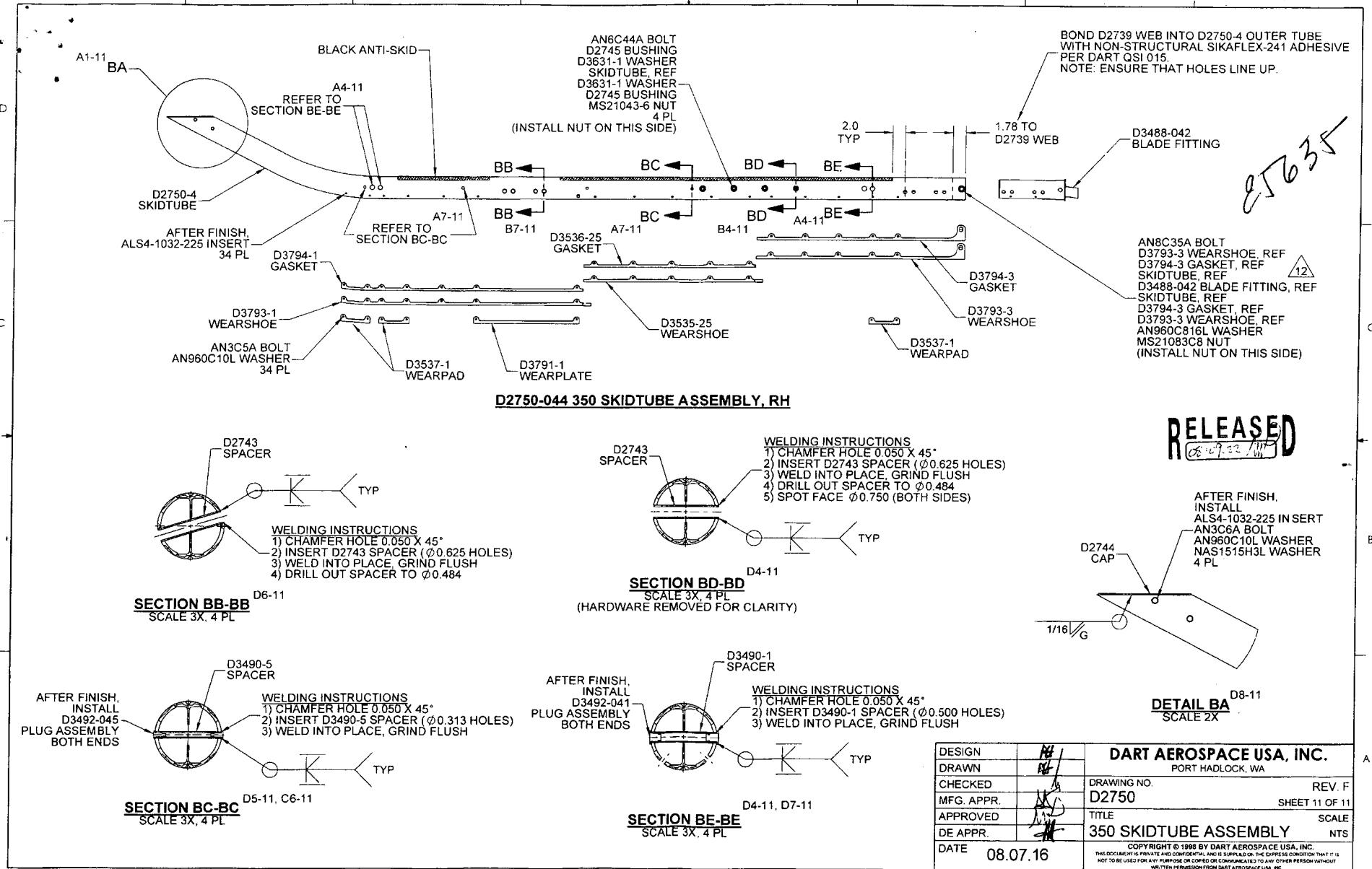
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

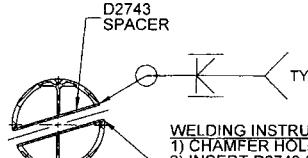


BOND D2739 WEB INTO D2750-4 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

85635

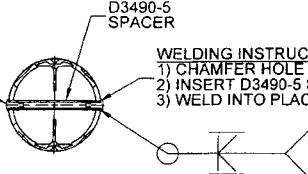
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
06-09-22 PM



WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (ϕ 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO ϕ 0.484

SECTION BB-BB D6-1
SCALE 3X 4 PI

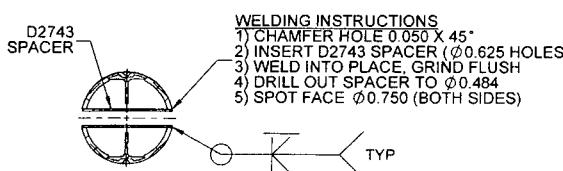


**AFTER FINISH,
INSTALL
D3492-045
PLUG ASSEMBLY
BOTH ENDS**

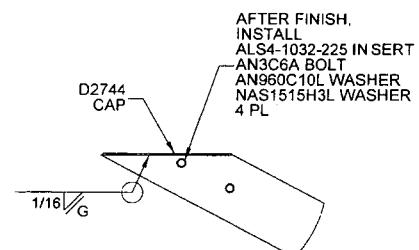
WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-5 SPACER (\varnothing .313 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

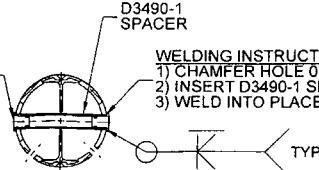
D5-11, C6-1



D4-11
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



D8-11



AFTER FINISH,
 INSTALL
 D3490-041
 PLUG ASSEMBLY
 BOTH ENDS
 SPACER
WELDING INSTRUCTIONS
 1) CHAMFER HOLE 0.050 X 45°
 2) INSERT D3490-1 SPACER (ϕ 0.500 HOLES)
 3) WELD INTO PLACE. GRIND FLUSH



SECTION BE-BE
SCALE 3X 4 PI

| | | | | |
|------------|-----------|---|----------------|-----|
| DESIGN | <u>NB</u> | DART AEROSPACE USA, INC. | | |
| DRAWN | <u>NB</u> | PORT HADLOCK, WA | | |
| CHECKED | <u>NB</u> | DRAWING NO. | REV. F | |
| MFG. APPR. | <u>NB</u> | D2750 | SHEET 11 OF 11 | |
| APPROVED | <u>NB</u> | TITLE | SCALE | NTS |
| DE APPR. | <u>NB</u> | 350 SKIDTUBE ASSEMBLY | | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 298

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: 87012
Part #: A350-636-014
Description: Skid tube
Welding Process: Tig Mig
Base material: Alum. Inox.
Current: AC DC

TEST REQUIREMENTS AND RESULTS

| | | |
|-------------------------|--|-------------------------------|
| Visual: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Incomplete Penetration: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Incomplete Fusion: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Cracks: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Overlap (cold lap) | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Undercut: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Pin holes: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Porosity (surface): | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Coloration: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Burn through: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |

Qualifier David Seidel Date of Test Coupon 12-07-23

Welder Barclay Elliott Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld